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D350-588-011
Job Sheet 195226



DAS
21
9-89

Part No: D350-588-011

Job Qty: 4 pcs

Part Name: Aft Door Fwd Hinge Modification



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/16/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9690 REV A , DSI9760-011 REV A , D350-588 REV D IPP Rev:M 04.08.31 Added D2690-17 KJ/JLM
IPP REV:G 14.04.28 AS PER DSI9690 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		6/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23	PC	JUN 03 2019
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	4 pcs	6/20/19	0.00	0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	JRD
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
130 Packaging 3-1 - Stock - B4B	4 pcs	6/20/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	M.D
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	4 pcs	6/20/19	0.00	0.00	DC - 1 - B4B	DAS 21 JUN 05 2019
					DC - 2 - B4B	9-88
140 QC 21 - FG	4 pcs	6/20/19	0.00	0.00	QC 21 - FG - 21	DAS 21 JUN 05 2019
					QC 21 - FG - 70	9-88
					QC 21 - SA - 53	

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location:

135 - Document Control - Photocopy bluefile and create labels per PPP D350-588-011 CHG002

140 - QC21- Final Inspection - Work Order Release

010137

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN526C1032R7	Screw	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	FM125403-4
AN526C832R8	Screw	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	5115606
AN526C832R9	Screw	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	5134859
D2143	Hinge Bracket	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5156248
D2144	Hinge Doubler	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5066408
D2150	Packer Doubler, Hinge	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5100799
D2151	Packer Doubler	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5064788
D2153	Door Prop	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5136664X2
D2154	Bracket, Stud	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5114679
D2237	Striker Plate	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5114708X4
D2461	Neoprene 'D' Seal (\$Per Foot)	29 ft (7.25 ea)	110-Packaging 1 - Pick Kit	5129504
D2463	1/2" Seal (\$ Per Foot)	29 pcs (7.25 ea)	110-Packaging 1 - Pick Kit	5140388
D2583	Latch Bracket	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5128525
D2585	Latch Clamp	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5129285
D2586	Door Latch	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5174406
D2587	Door Plug	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128520
D2589	Keys, Key Chain	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5137942
D2690-17	Cable	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5184887
D2857-1	Hinge Bracket	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5151552
D2857-2	Hinge Bracket	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5151503
D2858-1	Hinge Bracket	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5124487
D2858-2	Hinge Bracket	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5152164
D5080-041	Striker Plate Assembly	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5128948
FG-778150-550-ROL	7781 9 oz Glass 50" x 125 yd	4 sf (1 ea)	110-Packaging 1 - Pick Kit	FM124550-1
MS20426AD3-4	Rivet	48 Ea (12 ea)	110-Packaging 1 - Pick Kit	51136444
MS20470AD4-5	Rivet, Universal Head	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5134218
MS21042L08	Nut	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5157102
MS21042L3	Nut	16 Ea (4 ea)	110-Packaging 1 - Pick Kit	5166719
MS27039-08-11	Screw	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	51138336
MS27039-1-15	Screw	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	5114920
NAS1149D0363J	Washer	16 Ea (4 ea)	110-Packaging 1 - Pick Kit	5162884
NAS1149DN832J	Washer	96 Ea (24 ea)	110-Packaging 1 - Pick Kit	5131200X83

5185074X13

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN526C1032R7	8	102	0
	AN526C832R8	32	247	0
	AN526C832R9	32	567	0
	D2143	4	13	0
	D2144	4	12	0
	D2150	8	29	0
	D2151	8	28	0
	D2153	4	4	0
	D2154	4	16	0
	D2237	8	6	0
	D2461	29	311	0
	D2463	29	323	0
	D2583	8	5	0
	D2585	8	6	0
	D2586	8	57	0
	D2587	4	7	0
	D2589	4	151	0
	D2690-17	4	3	0
	D2857-1	4	16	0
	D2857-2	4	10	0
	D2858-1	4	12	0
	D2858-2	4	38	0
	D5080-041	8	28	0
	FG-778150-550-ROL	4	1,935	0
	MS20426AD3-4	48	2,529	0
	MS20470AD4-5	72	1,487	0
	MS21042L08	72	881	0
	MS21042L3	16	2,705	0
	MS27039-08-11	8	1,033	0
	MS27039-1-15	8	326	0
	NAS1149D0363J	16	1,777	0
	NAS1149DN832J	96	365	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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